

## User Guide for B/Ox™ 324

### 1.) Clean

Degrease area to be finished with a liquid detergent or E-Kleen 163 cleaner for **1-3 minutes**, or abrasively clean lacquered or heavily oxidized bare metal by belt sanding, glass bead, or sand blasting the surface. Do not use petroleum-based solvents.

### 2.) Rinse

Rinse with running water and a damp cloth or sponge to remove residual solutions or blasting dust.

- NOTE: If water breaks occur, return to step 1. Water breaks indicate the surface is not clean.

### 3.) Deoxidize & Rinse

Remove any surface oxide present with a steel scribe for narrow scratches, or steel wool or abrasive paper for wider areas. Then, rinse again as in step 2.

### 4.) Blacken

*For Small areas & Scratches:* Apply **full strength B/Ox 324** with cotton swab, sponge, or brush, using a light rubbing action for **30-90 seconds**. Ensure smooth and even coverage. If light brown color is preferred, dilute the solution with **1-3 parts water** prior to application.

*For Large areas or Job Site Application:* Blacken by repeatedly going over the *entire surface* with a sponge saturated with **full strength B/Ox 324**, distributing the solution over the *entire surface* on each pass. For wide vertical surfaces, it is recommended that sponges be attached to a board as wide as the area to be finished. Repeat **2-4 times** depending upon color desired. If a light statuary brown is desired, dilute solution with **4-8 parts water** prior to application.

- NOTE: Do not allow the solution to puddle.

### 5.) Rinse & Dry

Rinse with running water and a damp cloth or sponge. To remove the non-adherent layer of spent chemicals from the surface, either make several passes with a damp sponge, or polish the area with a soft cloth or brush (after drying.) Allow to air dry, or wipe or blow dry with compressed air.

- NOTE: Do not judge the final color until the protective topcoat has been applied. However, you may repeat steps 4, 5, and 6 if a darker finish is clearly needed.

### 6.) Seal

A variety of “highlighted” finishes can be achieved by buffing or scratch brushing with abrasive pads. The ultimate appearance and color of these “highlighted” finishes will be influenced by the natural color of the substrate (i.e. the alloy used) before blackening.

Seal by immersing while still wet from previous rinse in one of the following:

- *For a slightly oily finish:* E-Tec 502

- *For a soft, non-tacky, dry finish: E-Tec 505*
- *For a hard, clear acrylic finish: E-Tec 520*
- *For a clear hard wax finish: E-Tec 521*
- *For hand-applied wax topcoat: RENWAX.*

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Be sure to read and understand the Technical Data Sheets and Safety Data Sheets for each of these products before using them. Please see the B/Ox™ 324 Technical Data Sheet for more detailed processing instructions.